

Date: Friday, 5/25/2007 8:26:23 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 412 WEB
Job Number	: 32629		
Estimate Number	: 10466		
P.O. Number	: <i>N/A</i>	Part Number	: D33891
This Issue	: 5/25/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3389 REV C
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 32291	Drawing Revision	: C
		Material	: <i>N/A</i>
		Due Date	: 6/10/2007
Written By	: <i>[Signature]</i>	Qty:	4 Um: Each
Checked & Approved By	: <i>[Signature]</i> 07.05.28		
Comment	: Est Rev:A 05.08.31 New issue KJ/JLM		
	: Est Rev:B 06-02-08 As per Rev C JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D25003100	Ext'n -1' Beam Web 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 Ext'n -1' Beam Web 4"

Pick:

Qty	Part Number	Description	Batch
1	D2500-3-100	Web Extrusion	<i>B 25751</i>

JD 7-6-6

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1
 1-Cut to length as per Dwg D3389

2-Drill pilot holes using DT8785 as per Dwg D3389

3-Open 1X .257" Dia Hole

4-Open Remaining holes to finish size as per Dwg D3389

5-Deburr

JD 7-6-6

3.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

DP 7-6-6

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

JD 7-6-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: (D) Date: 27/06/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:26:23 AM
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Drawing Name: 412 WEB

Job Number: 32629

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



pm-07-06-18 (4)



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *LG*

JD 7-6-7

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

7/25/06/19

Job Completion



W 8-10-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

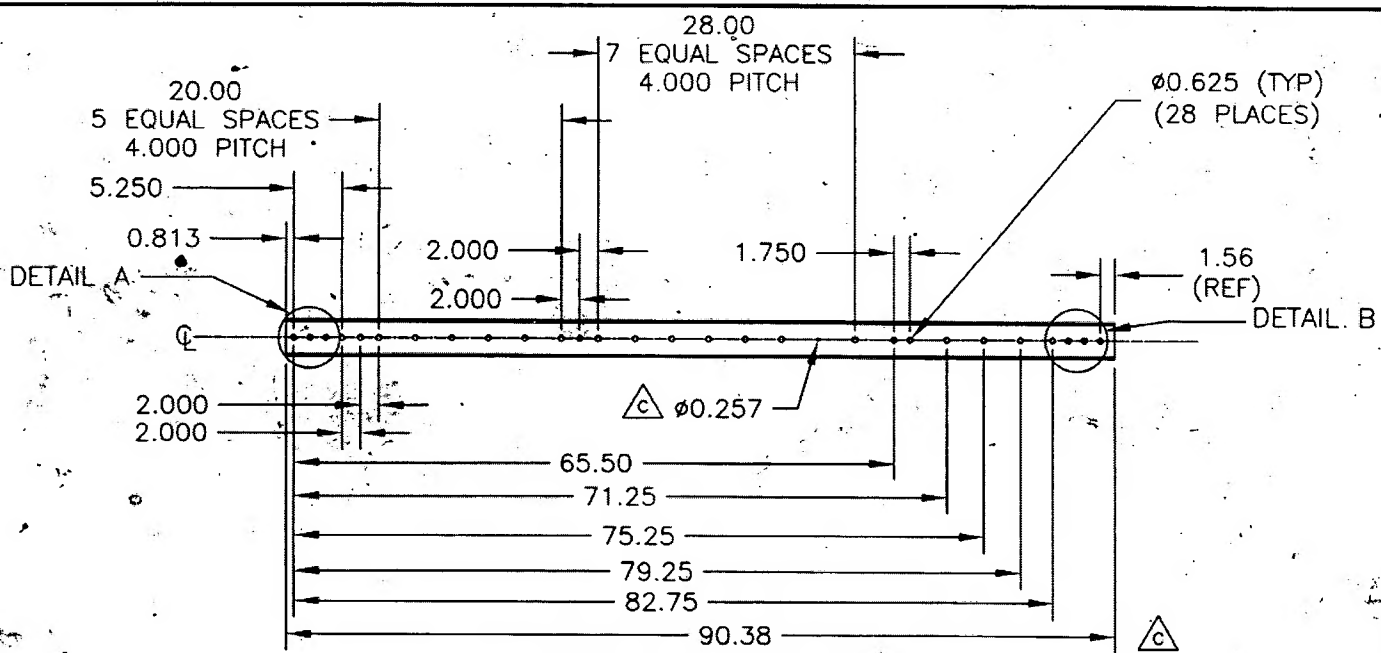
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

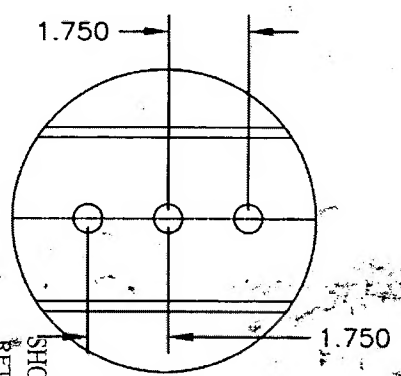
DART

RELEASE
06.01.23

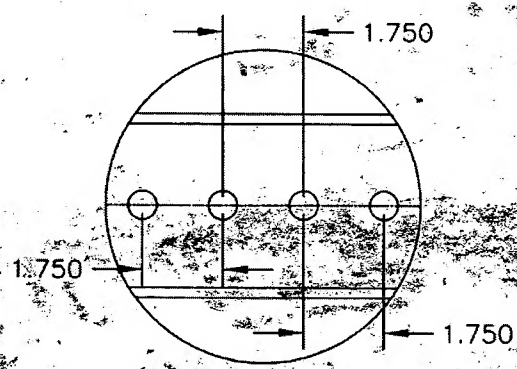
DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	REV. C
CHECKED	PH	APPROVED	PH	DRAWING NO.	03389	SHEET 1 OF 1
DATE	06.01.23	TITLE	412 WEB	SCALE	1:20	
A	05.02.07	NEW ISSUE				
B	05.06.13	UPDATE DIMENSIONING				
C	06.01.23	DECREASE OVERALL LENGTH, MODIFY HOLE				



D3389-1 DRILLING DETAIL



**DETAIL A
(SCALE 1:4)**



**DETAIL B
(SCALE 1:4)**

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 32629

D3389-1 412 WEB

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED